

Work Order ID 56251

Wednesday, February 17, 2010 11:03:30 AM

Page 1

Item ID: D2886-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Cable Guard

Start Date: 2/18/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2886

Rev A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANKS AS PER FILE D2886-1

A

A

NOT PULLED

R 10-2-17

140

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2886-1

ml 10/02/23

4 0

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

ml 10/02/23

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56251

Wednesday, February 17, 2010 11:03:30 AM

Page 2

Item ID: D2886-1

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

G.A 10/02/24

4

0

190

Identify as per dwg & Stock Location: 231

0.00



Packaging

Memo

0.00

Packaging

PL 10/3/0 1 (4)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03

CL 03/01/10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 17, 2010 11:03:29 AM

Page 1

Work Order ID: 56251



Parent Item: D2886-1



Parent Item Name: Cable Guard

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP A 99.06.23 New Issue DM

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB1750XT000 X4800		Purchased	No			100	sf	0.0000	0.7017			



~~UHMW 1.75x1.00x48.00~~

113903



113903

B 10-2-17

M4HmWB10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 56257
Description: GUARD		Part Number: D2886-1
Inspection Dwg: D2886 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

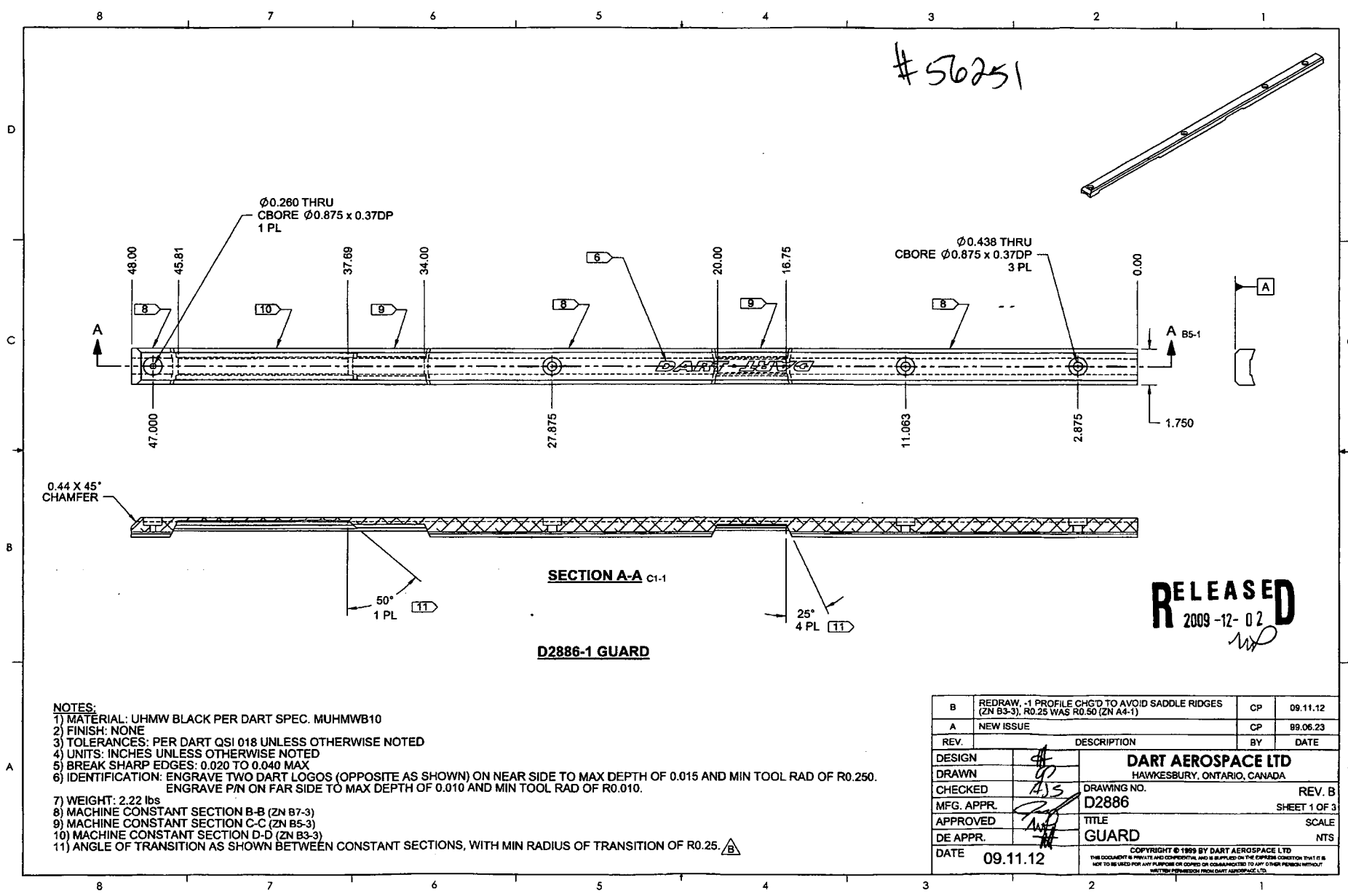
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	±.010	1.753	✓			
2.875	±.010	2.875	✓			
11.063	±.010	11.063	✓			
16.75	±.030	16.750	✓			
20.00	±.030	20.000	✓			
27.875	±.010	27.875	✓			
34.00	±.030	34.000	✓			
37.69	±.030	37.690	✓			
45.81	±.030	45.810	✓			
47.000	±.010	47.000	✓			
48.00	±.030	48.000	✓			
Ø.260	±.006	Ø.260	✓			
Ø.438	±.006	Ø.438	✓			
Ø.875	±.010	Ø.880	✓			
.37	±.030	.370	✓			
.44 X 45°	±.030 X ± 1/2°	.470 X 45°	✓			
.20 X 45°	±.030 X ± 1/2°	.225 X 45°	✓			
.70	±.030	.686	✓			
.79	±.030	.777	✓			
.95	±.030	.930	✓			
.78	±.030	.780	✓			
.33	±.030	.320	✓			
.50	±.030	.488	✓			

B-B {
C-C {

Measured by: <i>ML</i>	Audited by: <i>JA</i>	Prototype Approval:	N/A
Date: 10/02/23	Date: 10/02/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

#56251



RELEASED
2009-12-02
WJ

- NOTES:**
- 1) MATERIAL: UHMW BLACK PER DART SPEC. MUHMB10
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.020 TO 0.040 MAX
 - 6) IDENTIFICATION: ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON NEAR SIDE TO MAX DEPTH OF 0.015 AND MIN TOOL RAD OF R0.250. ENGRAVE P/N ON FAR SIDE TO MAX DEPTH OF 0.010 AND MIN TOOL RAD OF R0.010.
 - 7) WEIGHT: 2.22 lbs
 - 8) MACHINE CONSTANT SECTION B-B (ZN B7-3)
 - 9) MACHINE CONSTANT SECTION C-C (ZN B5-3)
 - 10) MACHINE CONSTANT SECTION D-D (ZN B3-3)
 - 11) ANGLE OF TRANSITION AS SHOWN BETWEEN CONSTANT SECTIONS, WITH MIN RADIUS OF TRANSITION OF R0.25.

B	REDRAW -1 PROFILE CHG'D TO AVOID SADDLE RIDGES (ZN B3-3), R0.25 WAS R0.50 (ZN A4-1)	CP	09.11.12
A	NEW ISSUE	CP	89.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.12		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2886	REV. B
TITLE GUARD	SHEET 1 OF 3
SCALE	NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

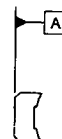
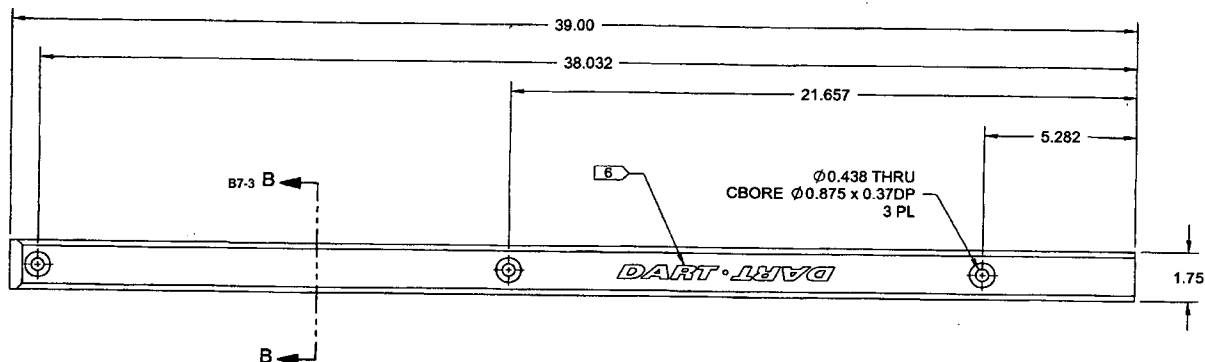
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NOTE: Date & initial all entries

#56251



0.44 X 45°
CHAMFER



D2886-3 GUARD

RELEASED
2009-12-02

NOTES:

- 1) MATERIAL: UHMW BLACK PER DART SPEC. MUHMWB10
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.040 MAX
- 6) IDENTIFICATION: ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON NEAR SIDE TO MAX DEPTH OF 0.015 AND MIN TOOL RAD OF R0.250.
ENGRAVE P/N ON FAR SIDE TO MAX DEPTH OF 0.010 AND MIN TOOL RAD OF R0.010.
- 7) WEIGHT: 2.20 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2886	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUARD	NTS
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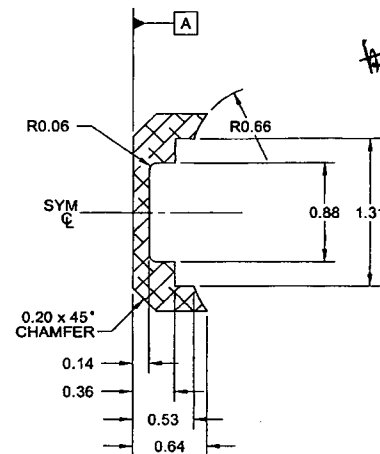
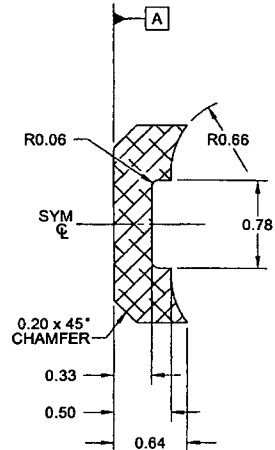
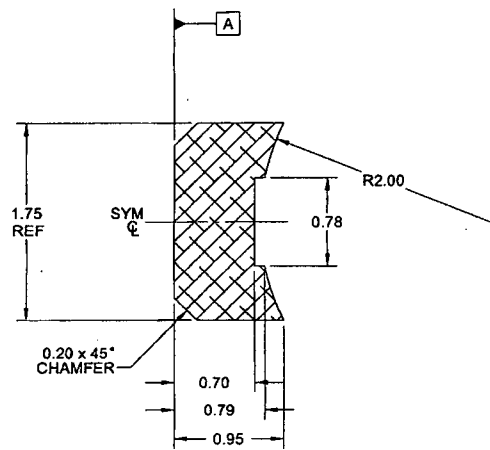
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



#56251

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2009-12-02

DESIGN	#	DART AEROSPACE LTD	
DRAWN	BS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BS	DRAWING NO.	REV. B
MFG. APPR.		D2886	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

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